

Work Order ID 163382

Tuesday, June 27, 2017 11:35:20 AM

163382

Page 1

Item ID: D4577-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fwd Access Panel Assembly
 Start Date: 7/5/2017 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 7/11/2017 Req'd Qty: 2.00 *2* Customer:

Reference:
 Approvals: Process Plan: DAC 21 Date: JUL 03 2017 Tooling: _____ Date: _____ Run Start *NR1*
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4577	C

100		0.00							
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100 FLOW WATER JET (2) 06/17/07/15
 Waterjet. Memo 0.31
 FLOW CNC Waterjet 1-Cut D4577-5 as per Dwg
 Dwg Rev: 6
 Prog Rev: 6
 2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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110 QC Memo 0.02 (2) 06/17/07/15
 Quality Control

120	QC8- Inspect parts - second check	0.00							
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120 QC Memo 0.04 2
 Quality Control
 DAS 38 9-89
 JUL 17 2017

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Item ID: D4577-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Access Panel Assembly
Start Date: 7/5/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 7/11/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab Small Fab	NC BRAKE Memo C'SINK HOLES AS PER DWG	0.00 0.18				<u>2x</u>			<u>17/07/18</u> DAS 36 9-89
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.04				<u>2</u>			<u>JUL 18 2017</u> DAS 38 9-89
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.52				<u>(x2)</u>	<u>0</u>		<u>20.7/07/31</u> BEB.

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/5/2017 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 7/11/2017 **Req'd Qty:** 2.00 ***?***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

AUG 01 2017

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Item ID: D4577-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Access Panel Assembly
 Start Date: 7/5/2017 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 7/11/2017 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	Identify as per dwg & Stock Location: <u>W4003</u>	0.00							
220									
Packaging	Memo	0.02							
Packaging									
230	QC21- Final Inspection - Work Order Release	0.00							
230									
QC	Memo	0.20							
Quality Control									

DAS
21
9-89
AUG 0 1 2017

Picklist Print

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Page 1

Work Order ID: 163382

163382

Parent Item: D4577-041

D4577-041

Parent Item Name: Fwd Access Panel Assembly

Start Date: 7/5/2017

Required Date: 7/11/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.03.08 NEW ISSUE DD VERF:EC IPP REV:B
12.04.25 AS PER DWG REV.B DD VERF:EC IPP REV:C 15.01.15
AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.125		Purchased	No			100	sf	41.3570	0.767	1.614737			
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M6061T6S 125

6061-T6 .125 Sheet

**

06/17/07/15

Location	Loc Qty	Loc Code
MAT019	36.96	
m136896	21.8	
m137515	15.16	
MAT020	4.397	
m136327	4.397	

MS20426AD3-5		Purchased	No			170	Each	3,166.000	10	20			
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MS20426AD3-5

Rivet

**

17/08/01
DAS
36
9-89

Location	Loc Qty	Loc Code
GA	2224	
4533	2224	
ST312	942	
4533	942	

NAS1474R3		Purchased	No			170	Each	10.0000	5	10			
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NAS1474R3

Anchor Nut

**

17/08/01
DAS
36
9-89

Location	Loc Qty	Loc Code
ST260	10	
m136866	10	

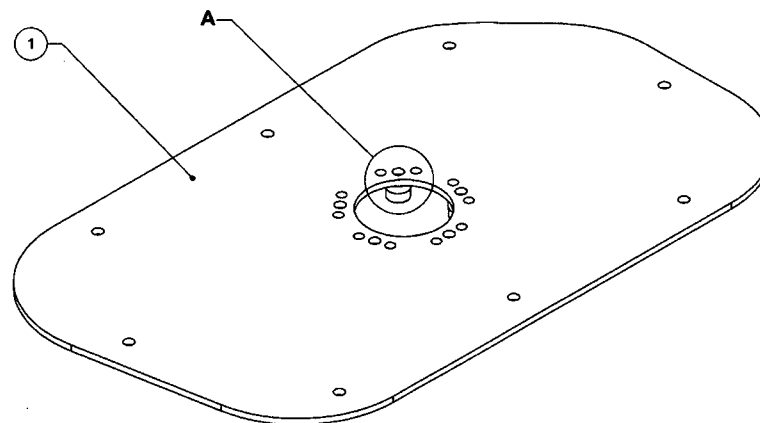
137963
10X

ITEM	QTY	P/N	DESCRIPTION
	X	D4577-041	FWD ACCESS PANEL ASSEMBLY
1	1	D4577-5	FWD ACCESS PANEL
2	10	MS20426AD3-5	RIVET, SOLID, CSK
3	5	NAS1474R3	ANCHOR NUT (OR NAS1474A3 OR NAS1474S3 OR NAS1474F3)

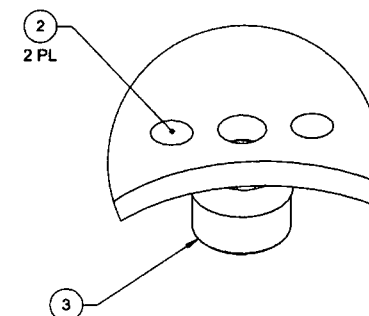
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163382 MJS
170703

RELEASED

2015 JAN 15



D4577-041 FWD ACCESS PANEL ASSEMBLY



DETAIL A
SCALE 4X
5 PL

NOTES:

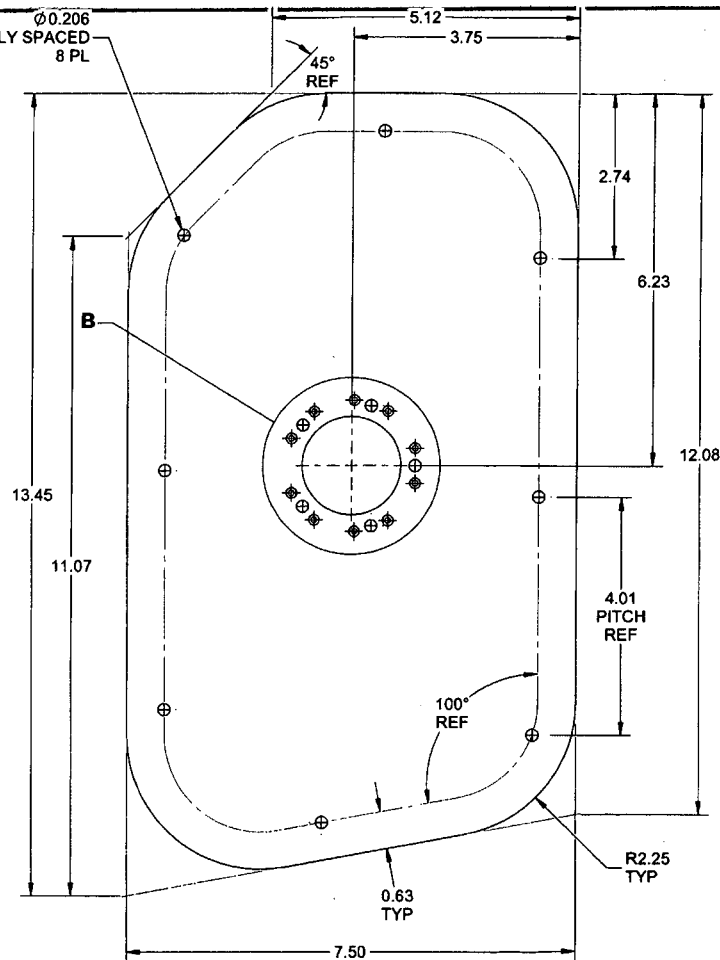
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.08 lbs

C	REMOVED POWDER COAT FINISH ON ALL PARTS (SHT 1-3); FORMAT UPDATED; REVISED WEIGHT (SHT 1). VARIOUS MINOR DIMENSIONAL CHANGES. ALL PARTS NOW FULLY DIMENSIONED; REMOVED UNNECESSARY VIEWS	AP	14.12.05
B	REMOVE D4001-1; ADDNAS1474R3, ZN C2-1. MODIFY -5 FOR HARDWARE, ZN C5-4. INCREASE THICKNESS OF -1/-3/-5; IS 0.125". WAS 0.063". MODIFY DIMS OF -1/-3/-5.	DC	12.03.30
A	NEW ISSUE	DC	12.01.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO. D4577	
MFG. APPR.	DD	REV. C	
APPROVED	MP	TITLE	
DE APPR.	DS	ACCESS PANEL	
DATE	14.12.05	SCALE	
		NTS	

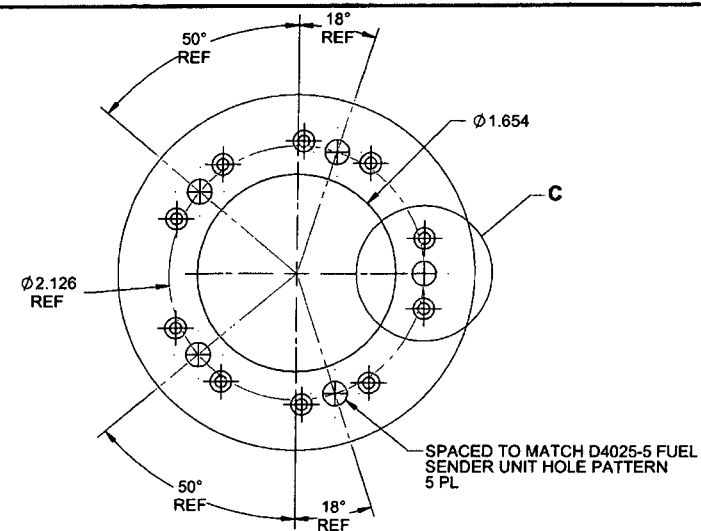
APPROVED

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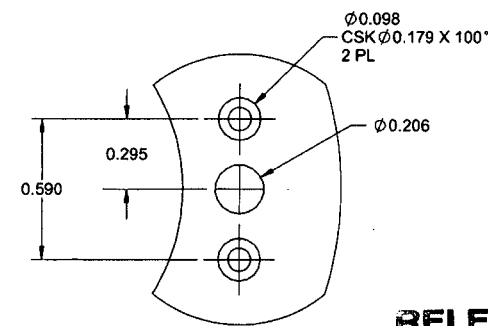
Ø 0.206
EQUALLY SPACED
8 PL



D4577-5 FWD ACCESS PANEL



DETAIL B
SCALE 2X



DETAIL C
SCALE 2X
5 PL

RELEASED

2015 JAN 15 *ap*

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.06 lbs

APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	DD	D4577	SHEET 4 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	ACCESS PANEL	NTS
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